Split

	r ID 71352 - \(\sigma\), 2011 1:51:00 PM	MAD.	dishu, IIII III			ASAP			Page 1
Revision ID:	D3401-041 Fow Cap Assembly	(4)	Accept			s s	etup Star Stop		
Start Date: Required Date: Reference:	6/28/2011 Start Qty: 8/00 7/13/2011 Req'd Qty: 8.00	30	l I	Cust Item I Customer:	D:				
Approvals:	Process Plan: MF	Date: (CO	フタ Tooling: SPC (Y/N):		ate:	R	tun Star Stop		
Sequence ID/ Work Center ID			Set Up/ Run Hours	Tool 1D	Tool# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3401	Revision Nbr Rev B								
Bandsaw Jeaspa Bandsaw	BAND SAW	iks 4.20" Long	0.00	(1 . 4 . 3	De e	8			
Doosan Lathe	DOOSAN LATHE Memo Turn as Folio Re Deburr	per Folio FA532 & Dwg D v	0.00 0.00 3401 Dwg Rev	is .6.	30	8			
QC Quality Control	QC2- Inspect parts o	ff machine FAI/FAIB	0.00	((· C	30	8			40,

W/O:			V	ORK ORDER CHANGE	ES					
DATE	STEP	PROC	EDURE CH	IANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Y	es N	o DQ	A:	_ Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Clos	ed:		_ Date: _	
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	CTED	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section		Chief Eng	QC Inspector

Tuesday, June 28, 2011 1:51:00 PM

Item ID:

D3401-041

Revision ID: Item Name:

Tow Cap Assembly

Start Date:

6/28/2011

Start Qty: 8.00

Required Date: 7/13/2011

Reg'd Qty: 8.00

Accept



Setup Start

Stop



OC:

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

Set Up/

Run Hours

SPC (Y/N):

Date:

Date:

Tool #

Plan

Code

Run Start

Reject

Qty

Accept

Qty



Number Stamp

Insp.

Stop

Reject

Sequence ID/

Work Center ID 130

HAAS 1

HAAS CNC vertical machine #1

Operation Description

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

0.00

0.00

0.00

Machine as per Folio FA532 and Dwg D3401 Dwg Rev: 13 Folio Rev: AA

Identify as D3401-1

QC2- Inspect parts off machine FAI/FAIB

Deburr & Buff rad as per Dwg D3401

135

OC

Quality Control

Memo

22 Rulouls

140

QC8- Inspect parts - second check

0.00

11 A 11/06/30

Memo

0.00

Quality Control

W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Frod Mgr	
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Dispositio	n:	QA: N/C Cld	sed:		Date: _	
NCR:		V	WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector

Tuesday, June 28, 2011 1:51:00 PM

Page 3

Item ID:

D3401-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Tow Cap Assembly

Start Date:

6/28/2011

Start Oty: 8.00 Reg'd Qty: 8.00 Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Plan

Code

Start

Reject

Qty

Run

OC:

Required Date: 7/13/2011

SPC (Y/N):

Set Up/

0.00

Run Hours

Date:

Tool#

Stop

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID 150

Small Fab

Operation

Description

Memo

Memo

0.00

SB 11/04/05

Accept

Qty

Small Fab

Small Fab

Drill and c'sink using DT8782 as per Dwg D3401

160

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Emosto

170

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

HandFinish

Memo

1 & Alulo7156

Hand Finishing

W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								T Tod Wigi	
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _	
		esolution:							
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NCF	R)			
DATE	OTED	Description of NC		Corrective Action , Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
		Q							

Tuesday, June 28, 2011 1:51:00 PM

Item ID:

D3401-041

Accept

Setup Start

Revision ID: Item Name:

Tow Cap Assembly

Start Date: 6/28/2011 Required Date: 7/13/2011

Start Oty: 8.00

Reg'd Oty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

OC:

Date:

Tooling:

Date:

Run

Start

Stop

Stop

Date:

SPC (Y/N):

Set Up/

Date: Tool ID

Tool # Plan

Code

Accept Oty

Reject Reject Otv

Number

Insp. Stamp

Sequence ID/ Work Center ID

Operation Description

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

Run Hours

0.00

180

Powdercoat

Memo

FINISH TIME:

0.00

Memo

OC3- Inspect Part Finish

0.00

Quality Control

195

Assemble as per dwg

0.00

HandFinish

Hand Finishing

Memo

0.00

Dail No.	Copace								
W/O:			W	ORK ORDER CHANGI	ES				17
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	s No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	QA: N/C	Closed:		Date: _	
NCR:		1	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
DATE	0755	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	1 & Sect	tion C	Chief Eng	QC Inspector
									1
						}			

Tuesday, June 28, 2011 1:51:00 PM

Item ID:

D3401-041

Accept

Setup Start



Revision ID: Item Name:

Tow Cap Assembly

Stop

Start Date:

6/28/2011

Start Oty: 8.00 Reg'd Qty: 8.00 Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

OC:

Required Date: 7/13/2011

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID 200

Quality Control

Operation Description

OC5- Inspect part completeness to step on W/O

Memo

Set Up/ Run Hours

Tool ID

Tool # Plan Code

Reject Accept Oty Oty

Run

Reject Number

Insp. Stamp

000 Sulo7/07

210

Packaging

Packaging

Identify as per dwg & Stock Location: PP-2

Memo

Memo

0.00

0.00

220

OC

Quality Control

OC21- Final Inspection - Work Order Release

0.00

0.00

CK 11/07/08 MF 11-07-07

W/O:			WC	ORK ORDER CHANGE	S				
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositio	n:	QA: N/C	Closed:		Date:	
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	OTED	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Sect	ion C	Chief Eng	QC Inspector
				9.					

Picklist Print

Tuesday, June 28, 2011 1:50:54 PM

Work Order ID: 71352

Parent Item:

D3401-041

Parent Item Name: Tow Cap Assembly



No

Start Date: 6/28/2011

Required Date: 7/13/2011

Start Qty: 8.00

Required Qty: 8.00

Page 1

Comi	** **	4	
C.OIIII	ne	m	

IPP A 05.09.01 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R3.500		Purchased	No			200	f.	11.5300	0.35	2.947368			
										26	1)	6	80

6061 RD bar 3.50

Location		Le	oc Qty	Loc Code	
MAT005	/		5.86		
	116808		5.86		
MAT036			5.67		
	110993		5.67		
		100	Each	710.0000	
					- 1



Insert

Location	Loc Qty	Loc Code
ST276	710	
102606	200	
103185	68	
103337	442	

	- copaco									
W/O:			WO	RK ORDER CHANGE	S					
DATE	STEP	PRO	OCEDURE CHAP	NGE	В	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	4)									
			_							
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	o DQ	A:	_ Date: _	
9	Re	esolution:	Disposition	n:	QA: N	C Clos	ed:		_ Date: _	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (I	VCR)				
DATE	STEP	Description of NC		Corrective Action Section			Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
										Ų.

P

D3401

DART

AEROSPACE PORT HABLOCK,

USA,

NC.

05

.06

.09

MOL THE

CAP ISSUE

> SCALE 9

05.06 05 .02

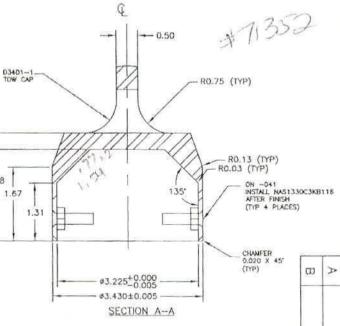
CHAMFER

INSIDE, REMOVE

RADIUS

.24 90

NEW



D3401-1/-041 TOW CAP

D3401-1 TOW CAP

MATERIAL:

MAKE FROM ALUMINUM 6061-T6 Ø3.500 ROUND BAR PER QQ-A-225/8 OR AMS-QQ-A-200/8 (REF. DART SPEC M6061T6R3.5000)

BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015

D3401-1 TOW CAP

0.500

3) ALL DIMENSIONS ARE IN INCHES

R1.25

20' ---

RO.38 4.00

DRILL 'E' (#0.250-#0.256) C'SINK (#0.391x100')

(4 PLACES)

4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.32

R0.70

DOCAY TO DOGS

2.75 2.83

2.45

2.08

D34D1-041 TOW CAP

ACID ETCH AND ALODINE PER DART QSI 005 4.1 FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

D3401-041 TOW CAP PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3401-1	TOW CAP
4	NAS1330C3KB116	INSERT





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SHT DOCUMENT OR COPIED

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:			Disposition	QA: N/C C	A: N/C Closed:				
NCR:			WORK ORDE	ER NON-CONFORMAN	ICE (NC	₹)		v	
DATE	STEP	Description of NC	Corrective Action Section B		1000	Verific	cation	Approval	Approval QC Inspector
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date			Chief Eng	

DART AEROSPACE LTD	Work Order:	71352
Description: Toe Cap	Part Number:	D3401-1
Inspection Dwg: D3401 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	×	First Article P		Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
Ø3.430	+/-0.005	2430	/		Vin	M1-7	
Ø3.225	+0.000/-0.005	3 222	/		1,	11	
1.31	+/-0.030	1.305	/		101	11	
2.08	+/-0.030	2.07	/		3.1	71	
2.45	+/-0.030	2.450	_/		((101	

23.430	.,, 0.000	3 7 2	8	cen	111-+
Ø3.225	+0.000/-0.005	3 222	/	* (11
1.31	+/-0.030	1.305	/	Try.	1.1
2.08	+/-0.030	2.07	/	3.1	7
2.45	+/-0.030	2.450	_/	C)	.0
4.00	+/-0.030	4.040	/	4	F
0.50	+/-0.030	.503		24	H
R0.75	+/-0.030	R.7-50	/	£ (· y · =

Measured by: 2/ 0ml	Audited by:	A	Prototype Approval:	N/A
Date: 11.6.30	Date: il C	30	Date:	N/A

Rev	Date	Change		Revised by	Approved
А	06.06.02	New Issue	P/O D3401-041	KJ/JLM X	911/

Dair	oopaoc	LIG							
W/O:			WC	RK ORDER CHANGE	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	By Date			Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ/	A:	Date:	
Resolution:			Disposition	QA: N/C Cld	QA: N/C Closed:				
NCR:		1	WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B		AND THE PARTY.	Verific	ation	Approval	Approval
DAIL	SILI	Section A	Initial Chief Eng	Action Description Chief Eng	on Sign & Se		on C Chief Eng		QC Inspector